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D117-762-041
Job Sheet 200537



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV.C (ecn16-514) DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	10/18/19		0.00	3.30	Skidtubes - 1		DO
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	10/18/19		0.00	3.30	Skidtubes - 1 - B4B		BE
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs	10/18/19		0.00	0.00	QC 10 - 10		SEP 24 2019
							QC 10 - 18		
							QC 10 - 24	DAS	
							QC 10 - 43	24	
							QC 10 - 50	9-89	
							QC 10 - 58		
							QC 10 - 9		
160	QC 5	1	10/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		



Container No: S215495



Part: D117-762-041

Job No: 200537

Serial No/Batch: S215495

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01853SE 19/09/04, TC STC LoA RDIMS-4374899 08/09/2019

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						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	SEP 24 2019 DA 40
						QC 5 - 61	9-89
						QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/18/19	0.00	0.97		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	SEP 24 2019
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
180 QC 7	1 pcs	10/18/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	
						QC 7 - 28	

					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	41 CG
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
190	Skidtubes - 3 - B4B	1 pcs	10/18/19	0.00 3.33	Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200	QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	EL
					QC 10 - 58	
					QC 10 - 9	
210	QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
215	Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.97	Handfinish - 2 - 1 - B4B	BE B19-09-28
					Handfinish - 2 - 2 - B4B	

9/12/2019,

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				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
220 Powdercoat - 1 White G(A)- B4B	1 pcs	10/18/19	0.00 0.26	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
230 QC 3	1 pcs	10/18/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	10/18/19	0.00 0.97	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 5	1	10/18/19	0.00 0.00	QC 5 - 10	

DAS
15
9-89

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			pcs			QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	OCT 03 2019
						QC 5 - 61	DAS 40
						QC 5 - 81	9-89
270	Packaging 3-1 - Stock - B4B	1	10/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	DAS 78
						Packaging 3 - 25 - B4B	9-89
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	DAS 21
						Packaging 3 - 36 - B4B	9-89
275	DC - 1 - B4B	1	10/18/19	0.00	0.00	DC - 1 - B4B	OCT 09 2019
		pcs				DC - 2 - B4B	
280	QC 21 - FG	1	10/18/19	0.00	0.00	QC 21 - FG - 21	DAS 21
		pcs				QC 21 - FG - 70	OCT 09 2019
						QC 21 - SA - 53	9-89

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Part Op 130 - Skid tubes-1 (Skid tubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.

140 - Skid tubes-1 (Skid tubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD

Batch: 138489/13901 2-Grind flush

150 - QC10 (QC10- Inspect visual per QSI004- ground welds)

160 - QC5 (QC5- Inspect part completeness to step on W/O)

170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

190 - Skid tubes-1 (Skid tubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R

241 Sika Flex Batch: 5200625 Exp Date: 07/25/2020 6- Swage x-bolt spacer as per dwg and

Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD

Batch: 138489 8-Grind welds flush

200 - QC10 (QC10- Inspect visual per QSI004- ground welds)

210 - (QC5- Inspect part completeness to step on W/O)

215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI

220 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME _____ OVEN TEMPERATURE:

FINISH TIME: _____

230 - (QC3- Inspect Part Finish)

250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 5200625 Exp Date: 267.2 3-Install Wearplates as per Dwg D3582 ,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install
 bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4

260 - (QC5- Inspect part completeness to step on W/O)

270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081

275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

012193

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	S207225
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	S122988
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	S141305
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	S174162
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	S097034
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	S174779
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	S173644
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	F81616
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	S148275
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	S053257
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	S147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	S149158
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	S090636
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	S183116
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S166570
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S132981
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S172982
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S132571
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S172977
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S177366
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S210686
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S177344
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	S177339
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	S180131
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	S178370
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	F813121

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	5	0
	D5520-1	2	6	0
140-Skidtubes - 2 - B4B	D2964	1	24	0
	CR3212-5-05	68	282	0
190-Skidtubes - 3 - B4B	D2971	1	63	0
	D3584-1	1	6	0
250-Handfinish - 4-1-Assembly-B4B	D3662-1	3	19	0
	D3662-3	1	36	0
	D5304-1	2	9	0
	ALS4-1032-130	36	6,008	0
	ALS4-428-165	2	72	0
	AN3-5A	2	38	0
	AN3C4A	28	584	0
	AN4-4A	2	50	0
	D2965	1	52	0
	D3508-11	1	13	0
	D3508-13	1	9	0
	D3508-3	1	16	0
	D3508-9	1	14	0
	D3558-11	1	13	0
	D3558-13	1	5	0
	D3558-3	1	14	0
	D3558-9	1	14	0
	NAS1149C0332R	28	3,072	0
	NAS1149D0332J	2	1,944	0
	NAS1149D0416J	2	1,781	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3882-041	SKIDTUBE ASSEMBLY
1	1	D2882-180	EXTRUSION
2	1	D2884	CAP
3	1	D2885	CAP
4	1	D2871	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-8	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-8	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3882-1	CROSS BOLT SPACER
15	1	D3882-3	CROSS BOLT SPACER
16	2	D3804-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3CA4	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN880C10L)
22	2	NAS1149D0332J	WASHER (AN880JD10L)
23	2	NAS1149D0416J	WASHER (AN880JD416L)
24	38	AELS-1032-130	INSERT
25	2	AL37-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

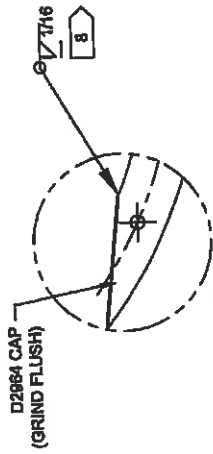
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 18.2 lbs
8) WELDING: PER DART QSI 004.
9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SKIAFLX-2411-281 ADHESIVE PER DART QSI 016 AFTER BENDING.
10) USE DART DRILL TEMPLATE DTR800 TO LOCATE AND DRILL Ø.1297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SKIAFLX-2411-281.
11) DO NOT INSTALL AN3CA4 BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø.161 THRU SKIDTUBE AND DOUBLER USING DT10308. COUNTERSINK Ø.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

RELEASED
2017-08-11
2017-5-47

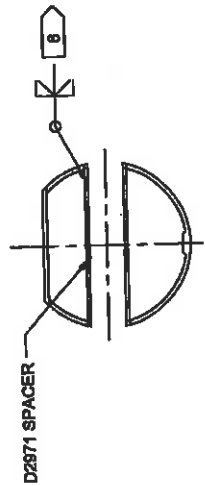
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RETURN
ENGINE
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WIT
W/O

NO. 200537 MWS
1909-12

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 28 AND NOTE 12-13. Ø.161 HOLE WAS Ø.076. ADD SHT 3, ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3804-1 WAS D2873. REVISE BOM & SECTION F-F & SECTION NOTES (ZN BT-3, A9-3); REF NCR18-8180	RF	17.01.08
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	28.88 WAS 28.87 (ZN C2-1), INCORPORATED DEO D3582-A-1 (ZN D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	AJS	
DRAWN	AJS		
CHECKED			
MFG. APPR.	DD		
APPROVED			
DE APPR.			
DATE	17.03.27		
DART AEROSPACE USA, INC			
EUGENE, OR			
DRAWING NO. D3582			
TITLE 9K 117 SKIDTUBE ASSEMBLY			
SHEET 1 OF 4			
REV. E			
N/A			
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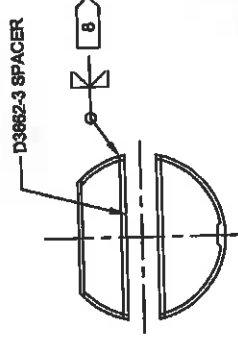


DETAIL C
SCALE 4X



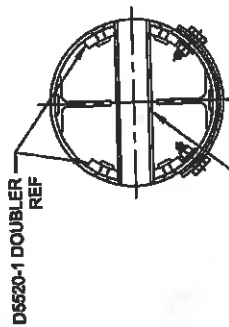
SECTION D-D
SCALE 4X

- SECTION D-D NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2871 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER



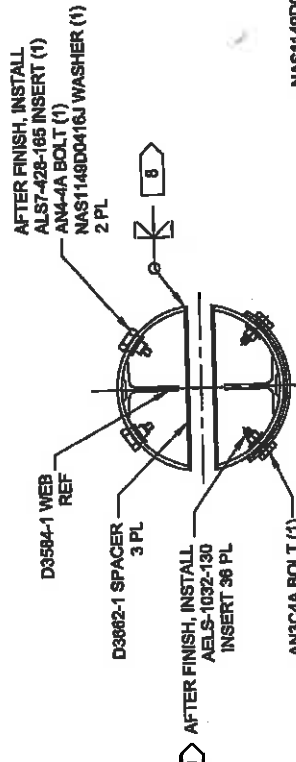
SECTION E-E
SCALE 4X

- SECTION E-E NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D3862-3 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.872 DRILL TO REMOVE SPILL OVER



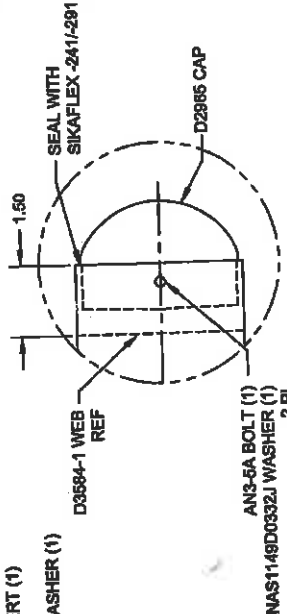
SECTION F-F
SCALE 4X

- SECTION F-F NOTES**
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
 2. SWAGE TO Ø0.565 +0.005/-0.000 X 1.0
 3. DEEP PER QSI 002
 4. OPEN THRU HOLE TO Ø0.625



SECTION G-G
SCALE 4X

- SECTION G-G NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D3862-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



DETAIL H
SCALE 4X

DESIGN	PH	REV. E
DRAWN	AJS	
CHECKED		
MFG. APPR.		
APPROVED		
DATE	17.03.27	

DART AEROSPACE USA, INC	EUGENE, OR	REV. E
DRAWING NO.	D3582	SHEET 3 OF 4
TITLE	BK 117 SKIDTUBE ASSEMBLY	SCALE
DATE	17.03.27	NTS

RELEASED
2017-08-11



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By		MRB (QS1042)			
Lead hand / Supervisor		QC / QA Coordinator			